

# Work Order ID 63143

Thursday, October 21, 2010 2:34:29 PM



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Item ID:	D3928-1	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Bracket					
Start Date:	10/22/2010	Start Qty:	14.00		Cust Item ID:	
Required Date:	10/29/2010	Req'd Qty:	14.00		Customer:	
Reference:						

Approvals:	Process Plan:	<u>MF</u>	Date:	<u>10-10-21</u>	Tooling:		Date:		Run	Start	
	QC:		Date:		SPC (Y/N):		Date:			Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D3928	B

100		0.00
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Waterjet  
FLOW CNC Waterjet  
6061.000

Memo  
1-Cut as per Dwg D3928  
Dwg Rev: B  
Prog Rev: B  
\*\*\*grain along 4.97"\*\*\*  
2-Deburr if necessary

0.00

B10-11-1



110	QC2- Inspect parts off machine FAI/FAIB	0.00
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QC  
Quality Control

Memo

0.00

B10-11-1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



**NOTE:** Date & initial all entries




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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC8- Inspect parts - second check  Memo	0.00  0.00		Spolulo 1		count 27			
130  Brake NC Brake NC	Memo 1- Bend as per dwg	0.00  0.00		SB 1011102		27			
140  QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00  0.00		Spolulo 2		count 27			

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Required Date:	10/29/2010	Req'd Qty: 14.00		Customer:		
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1  Memo	0.00  0.00							
			=> ell	1011103		27			
160  Powdercoat Powder Coating	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum M115291. Memo Start Time: 11:25 Oven Temperature: 320° Finish Time: 11:55	0.00  0.00							
						27			PR 10-11-9
170  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00							
			=> ell	1011109		27			

W/O:		WORK ORDER CHANGES					
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**Work Order ID 63143**

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Item ID: D3928-1

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Setup Start

Revision ID:

Stop

Item Name: Bracket

Start Date: 10/22/2010 Start Qty: 14.00

Required Date: 10/29/2010 Req'd Qty: 14.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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180

Identify as per dwg &amp; Stock Location: 090

0.00



Packaging

Memo

0.00

Packaging

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/14/10 (27)

OK 10/11/10

MK  
10-11-10

W/O:		WORK ORDER CHANGES					
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# Picklist Print

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Page 1

Work Order ID: 63143

Parent Item: D3928-1

Parent Item Name: Bracket



Start Date: 10/22/2010

Required Date: 10/29/2010

Start Qty: 14.00

Required Qty: 14.00

Comments: IPP RevA: New issue DD verified by:EC  
10.10.21 as per revB DD verified by:

IPP Rev:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.050

Purchased

No

100

sf

201.3900

0.0735

1.083158

1.8



HB10-11-1

6061-T6.050 Sheet

Location

Loc Qty

Loc Code

MAT

166.8

114799

38.8

114993

128

MAT21

34.59

110791

3

113216

31.59

110791

~~27~~ 27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

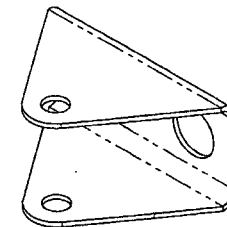
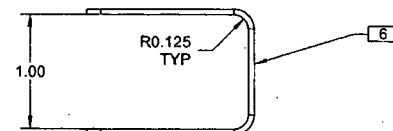
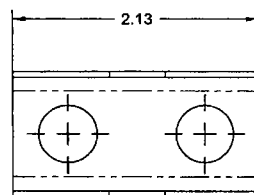
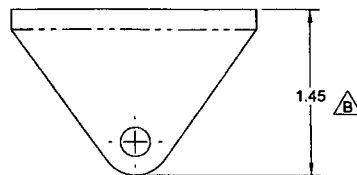
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries





**D3928-1 BRACKET**  
MADE FROM D3928-1F

**RELEASED**  
2010-09-15  
JW

#63143

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3928-1" AND B/N PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: 0.03 lbs

B	1.45 WAS 2.05 (D5-1), 3.78 WAS 4.97 (D5-2), BLACK FINISH WAS WHITE (A8-1)	CP	10.08.22
A	NEW ISSUE	BY	09.04.01
REV.	DESCRIPTION	BY	DATE
DESIGN	<b>DART AEROSPACE USA, INC.</b> PORT HADLOCK, WA  DRAWING NO. <b>D3928</b>  TITLE <b>BRACKET</b>		
DRAWN			
CHECKED			
MFG. APPR.			REV. B
APPROVED			SHEET 1 OF 2
DE APPR.			SCALE
DATE			NTS
10.08.22			
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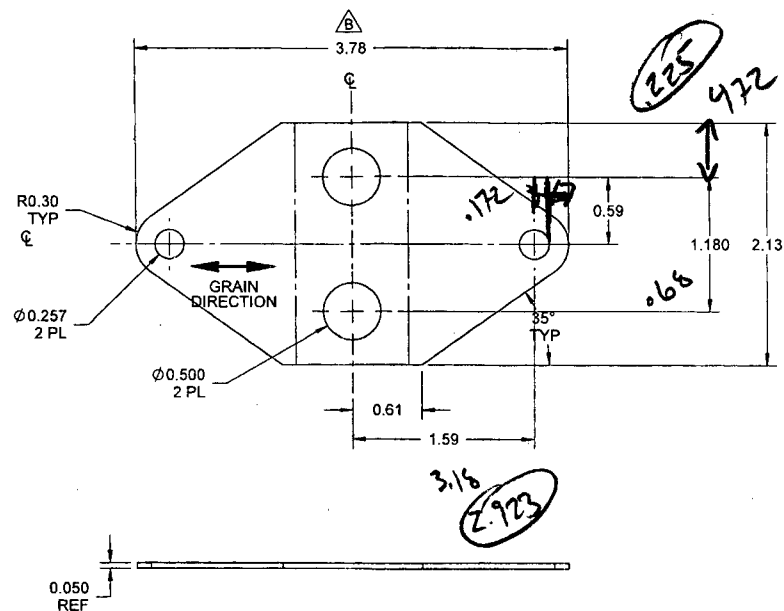
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**D3928-1F BRACKET FLAT PATTERN**

#63443

**RELEASED**  
2010-09-15  
NTS

**NOTES:**

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET 0.050 THICK PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.03 lbs

DESIGN	90	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	90	PORT HADLOCK, WA	
CHECKED	10	DRAWING NO.	REV. B
MFG. APPR.	10	D3928	SHEET 2 OF 2
APPROVED	10	TITLE	SCALE
DE APPR.	10	BRACKET	NTS
DATE	10.08.22	<small>COPYRIGHT © 2009 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL. NO DISSEMINATION OR REPRODUCTION OF THIS DOCUMENT IS PERMITTED WITHOUT THE WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small>	

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